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D4005-1

Job Sheet 192625



Part No: D4005-1

Job Qty: 4 pcs

Part Name: Rear Restraint Angle Gutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 14928

Note: DWG REV B SHEETS 2,3 IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 10.11.11 added abrasion strip DD verified by:E IPP Rev:D 12.03.07 as per dwg rev.b DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	4/12/19	4/12/19	0.00	0.25	Waterjet - Flow		02/19/04/10
120	QC 8	4 pcs	4/12/19	4/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	4 pcs	4/12/19	4/12/19	0.00	0.16	Small Fab - Brake - 1 - B4B		APR 11 2019
							Small Fab - Brake - 2 - B4B		

DAS
40
9-89

APR 11 2019

APR 5 2019

				Small Fab - Brake - 3 - B4B	
135 QC 5	4 pcs	4/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/12/19	0.00 0.20	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
145 QC 7	4 pcs	4/12/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	

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APR 15 2019

D.R 19/07/15

BK 19-4-16

				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
150 Powdercoat - 9 Gloss Grey-B4B	4 pcs	4/12/19	0.00 0.08	Powdercoat - 1 - B4B	
M 122878				Powdercoat - 2 - B4B	
START: 8:20 O.T.: 300 FINISH: 8:50				Powdercoat - 3 - B4B	BK 194-16
				Powdercoat - 4 - B4B	
160 QC 3	4 pcs	4/12/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS 58 9-89
				QC 3 - 59	APR 16 2019
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
164 Small Fab - 2 - B4B	4 pcs	4/12/19	0.00 0.65	Small Fab - 1 - B4B	DAS 58 9-89
				Small Fab - 2 - B4B	APR 16 2019
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
166 QC 5	4 pcs	4/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 9-89
170 Packaging 3-1 - Stock - B4B	4 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	APR 16 2019
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	APR 16 2019

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	DAG 21 APR 10 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - QC8- Inspect parts - second check
 Descriptions: 130 - Bend/Assemble as per dwg
 135 - QC5- Inspect part completeness to step on W/O
 140 - Chemical Conversion Coat per QSI005 4.1
 145 - QC7-Inspect Chemical Conversion Coat
 150 - Gloss Grey (4.3.5.15) per QSI 005 4.3)
 160 - QC3- Inspect Part Finish
 164 - Small Fab
 166 - QC5- Inspect part completeness to step on W/O
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	.5804 sf (.1451 ea)	100-Waterjet - Flow - 1	5146235
D2856-100-1100	Abrasion Strip	4 pcs (1 ea)	164-Small Fab - 2 - B4B	5172821

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	1	114	0
164-Small Fab - 2 - B4B	D2856-100-1100	4	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rear Restraint Angle Gutter	1.810Inches $\pm$ 0.030	1.840 1.780		
2	Rear Restraint Angle Gutter	11.020Inches $\pm$ 0.030	11.050 10.990		
3	Rear Restraint Angle Gutter	0.130Inches $\pm$ 0.030	0.160 0.100	Diameter	
4	Rear Restraint Angle Gutter	0.063Inches $\pm$ 0.010	0.073 0.053		

Plex 3/28/19 1:59 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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AEROSPACE

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Container No: S171237

Part: D4005-1

Job No: 192625

Serial No/Batch: S171237

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/10/19